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**IN THE UNITED STATES PATENT AND TRADEMARK OFFICE  
BEFORE THE BOARD OF PATENT APPEALS AND INTERFERENCES**

In re the Application of: **Yasushige NAKAMURA et al.**

Group Art Unit: **1756**

Serial Number: **09/935,668**

Examiner: **Janis L. Dote**

Filed: **August 24, 2001**

Confirmation Number: **1050**

For: **IMAGING COLOR TONER, COLOR IMAGE FORMING METHOD  
AND COLOR IMAGE FORMING APPARATUS**

Attorney Docket Number: **011071**

Customer Number: **38834**

**SUBMISSION OF APPEAL BRIEF**

Commissioner for Patents  
P.O. Box 1450  
Alexandria, Virginia 22313-1450

March 31, 2006

Sir:

Applicants submit herewith an Appeal Brief in the above-identified U.S. patent application.

Attached please find a check in the amount of \$500.00 to cover the cost for the Appeal Brief.

If any additional fees are due in connection with this submission, please charge our Deposit Account No. 50-2866.

Respectfully submitted,

**WESTERMAN, HATTORI, DANIELS & ADRIAN, LLP**

Kenneth H. Salen

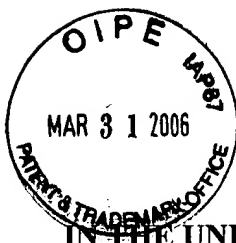
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KHS/rf



IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

**BEFORE THE BOARD OF PATENT APPEALS  
AND INTERFERENCES**

**APPEAL BRIEF FOR THE APPELLANT**

**Ex parte Yasushige NAKAMURA et al.**

**IMAGING COLOR TONER, COLOR IMAGE FORMING METHOD AND COLOR  
IMAGE FORMING APPARATUS**

Serial Number: **09/935,668**

Filed: **August 24, 2001**

Appeal No.:

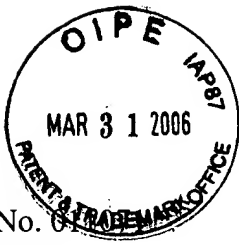
Group Art Unit: **1756**

Examiner: **Janis L. Dote**

Submitted by:  
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**March 31, 2006**



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Serial No. 09/935,668

**BRIEF ON APPEAL**

**(I) REAL PARTY IN INTEREST**

The real party in interest is FUJI XEROX CO., LTD., by an assignment recorded in the U. S. Patent and Trademark Office on March 27, 2003, at Reel 013877, Frame 0741.

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**(II) RELATED APPEALS AND INTERFERENCES**

There are no other appeals or interferences known to appellant, appellant's legal representative, or assignee that will directly affect or be directly affected by or have a bearing on the Board's decision in the pending appeal.

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**(III) STATUS OF CLAIMS**

Pending claims 1, 3-5, 7, 9-11, 13, 14 and 18-22 are rejected and are herein appealed.

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**(IV) STATUS OF AMENDMENTS**

This Appeal is filed following submission by Appellant of a Request for Continued Examination filed with an Amendment on October 6, 2005. The Amendment was entered and rejected in a Non-Final Office Action dated November 3, 2005. No amendments were filed subsequent to the Non-Final Action. However, Final Office Actions were previously forwarded by the Patent Office dated September 30, 2002, January 12, 2004 and April 7, 2005.

**(V) SUMMARY OF CLAIMED SUBJECT MATTER**

Rejected claims 1, 19, 20 and 22 and claims 3, 4, 5, dependent therefrom are grouped and represented by the independently claimed subject matter of claim 1, which is described in the specification in the following locations:

Claim	Specification Locations
1. (Previously Presented) An imaging color toner comprising at least a binder resin, a colorant and an infrared absorber, wherein	
the binder resin contains, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;	Page 8, lines 2-5
the first polyester resin is a crosslinked polyester resin having a softening point Tsp of not lower than 120°C and lower than 170°C, and also contains 1 to 25 parts by weight of a chloroform-insoluble content as the component; and	Page 8, lines 6-10 Page 8, lines 17-20 Page 8, lines 32-36
the second polyester resin is a <b>non-crosslinked polyester resin</b> having a softening point Tsp of not lower than 80°C and lower than 110°C, wherein the toner is capable of being photofixed; and	<b>Examples 2-1 → 2-5</b> Page 8, lines 25-26
wherein an acid value of the first polyester resin is from 20 to 40, an acid value of the second polyester resin is from 5 to 20, and an acid value of the entire polyester resin is from 15 to 35.	Page 9, lines 11-14

Claims 7, 11 and claims 9, 10, 13 and 14, dependent therefrom are represented by claim

7, which finds support in the specification in the following locations:

7. (Previously Presented) A method of forming a color image on a recording medium which comprises the steps of forming an electrostatic latent image by image exposure, visualizing the electrostatic latent image by development, transferring the visualized image onto the recording medium and fixing the transferred image, wherein	Page 17, line 14 – page 18, line 1
a developing agent comprising a color toner, which comprises at least a binder resin, a colorant and an infrared absorber, is used in the step of developing the electrostatic latent image,	Page 7, lines 26-29
the binder resin containing, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;	Page 8, lines 2-5
the first polyester resin being a crosslinked polyester resin having a softening point Tsp of not lower than 120°C and lower than 170°C, and also containing 1 to 25 parts by weight of a chloroform insoluble content as the component; and	Page 9, line 5 Page 8, lines 6-10 Page 8, lines 17-20 Page 8, lines 32-36
the second polyester resin being a polyester resin having a softening point Tsp of not lower than 80°C and lower than 110°C, said second polyester resin being a polymerization product of polyoxypropylene (2.2)-2, 2-bis (4-hydroxyphenyl) propane, polyoxyethylene (2.2)-2, 2-bis (4-hydroxyphenyl) propane and terephthalic acid <b>in the absence of a crosslinking component</b> ; and	Page 8, line 11 Page 8, lines 25-26 Page 12, lines 7-19
a photofixing system is used at a light emission energy density ranging from 1.0 to 6.0 J/cm <sup>2</sup> in the step of fixing the transferred image after transferring the image visualized by using the developing agent onto the recording medium;	<b>Examples 2-1 – 2-5</b> Page 17, lines 25-28
wherein an acid value of the first polyester resin is from 20 to 40, an acid value of the second polyester resin is from 5 to 20, and an acid value of the entire polyester resin is from 15 to 35.	Page 9, lines 11-14



**(VI) GROUNDS OF REJECTION TO BE REVIEWED ON APPEAL**

Claims 1, 3-5, 7, 9-11, 13, 14 and 18-22 are rejected under 35 U.S.C. §112, first paragraph, as failing to comply with the written description requirement.

The Examiner notes that the originally filed specification only refers to the second polyester as a “non-linear” polyester resin, rather than:

- the “non-crosslinked” or “linear” polyester as recited in claims 1, 3-5 and 18-22, and
- the “the second polyester resin being a polymerization product...in the absence of a crosslinking component” as recited in claims 7, 9-11, 13 and 14.

The Examiner asserts that exemplified second polyester resin 2-4 is the only disclosure of a second polyester resin having a Tsp of 110°C and an acid value as recited in instant claims 19 and 22. The Examiner asserts that the single exemplified species of a linear, non-crosslinked polyester resin 2-4 does not provide an adequate written description of the broad second non-cross-linked polyester resin recited in claim 19 and the linear polyester recited in claim 22. The Examiner concludes that a person having ordinary skill in the art would not have necessarily recognized that the one exemplified species is representative of the entire scope of the broad second non-crosslinked polyester resin and broad linear polyester resin recited in the instant claims.

**(VII) ARGUMENT**

The Limitations Rejected as New Matter are not New Matter because One Skilled in the Art Would Have Not Only Recognized the Existence of the Error in the Specification, but Also Recognized the Appropriate Correction.

An amendment to correct an obvious error does not constitute new matter where one skilled in the art would not only recognize the existence of error in the specification, but also the appropriate correction. *In re Oda*, 443 F.2d 1200, 170 USPQ 268 (CCPA 1971); Manual of Patent Examining Procedure §2163(I)(B).

Appellant asserts that one skilled in the art at the time of the invention, upon reading the specification, would have recognized the existence of the error in the specification, i.e., that the description of the non-crosslinked polymer as “non-linear” was an error, and would have realized that the correction would have been that the second polymer should have been referred to as “non-crosslinked” (claims 1 and 19) or “linear” (claims 20 and 22). Such understanding would have arisen based on the descriptions in the examples in the specification.

As is well-known in the chemical field, in the preparation of polyesters, when the divalent monomer containing only two reactive (-OH) groups is used in combination with the trivalent monomer containing three reactive (-COOH) groups, i.e., trimellitic acid (crosslinking component), as in the first polyesters of the present invention, the resulting product is a “non-linear” polyester having a “crosslinked” structure. The first polyesters of the present invention are thus crosslinked and non-linear, as properly described in the specification.

However, when only the divalent monomers containing only two reactive (-OH) groups are used as the starting material as in the second polyesters of the present invention, the resulting product is “linear” polyester having a “non-crosslinked” structure, because one monomer contains only two bonding sites. The second polyesters of the present invention are thus clearly non-crosslinked and linear.

The use of divalent monomers is described on page 10, line 32 to page 12, line 30 of the text. The use of the trivalent monomers such as trihydric or polyhydric carboxylic acids and trihydric or polyhydric alcohols are described on page 11, lines 16 to 22 and page 12, line 31 to page 13, line 1 of the text.

Appellants refer to the Declaration of Dr. Masatoshi Kimura dated August 5, 2003, which indicates that the Declarant, upon reading the specification, both easily recognized that an error was apparent, and also easily recognized what the correct meaning should have been.

In his declaration, Dr Kimura noted that that above facts are apparent for an expert in polymer chemistry. Dr. Kimura noted the above-noted use and non-use of crosslinking agents in the examples in the specification, i.e., Polyesters 2-1 to 2-5 produced by reaction of only divalent monomers, and concluded that the second claimed polyesters are linear polyesters having non-crosslinked and linear structure.

Therefore, Appellant submits that one skilled in the art would realize that the description of the non-crosslinked polymer as “non-linear” was an error, and would realize that the error was in calling the second polymer “non-linear”.

The Fact That Not All of the Examples Are Representative of All of the Claimed Limitations Does Not Diminish Their Value in Illustrating the Existing Obvious Error to One Skilled in the Art.

The Examiner notes that the second resins 2-1, 2-4 and 2-5 are outside the scope of instant claims 1, 7 and 11, because they have Tsp of 70, 110 and 120°C, respectively, which are outside the range of “not lower than 80°C and lower than 110°C” recited in those claims. The Examiner resubmits that the two remaining samples of non-crosslinked polyester resins, 2-2 and 2-3, do not provide an adequate written description of the broad second non-crosslinked polyester resin recited in claims 1, 7 and 11. The Examiner disregards the probative value of the disregarded examples, and concludes that a person having ordinary skill in the art would not necessarily have concluded that the two remaining examples are representative of the entire scope of the broad second non-crosslinked polyester resin recited in the instant claims.

Appellant respectfully disagrees. Appellant notes that *all* of the examples 2-1 to 2-5 disclosed in the specification include second polyesters that are linear and non-crosslinked, because they do not include any crosslinking agent. Conversely, none of the examples disclosed in the specification include second polyesters that are non-linear and crosslinked, again because they do not include any crosslinking agent.

All of the Examples are representative of at least portions of the claimed invention, and all of the Examples contribute to the teachings of the specification. Appellant submits that even if one skilled in the art would have recognized only Examples 2-2 and 2-3 as supporting the

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entire claimed invention, one skilled in the art would by necessity still have looked to all of the examples in the specification, and would have confirmed from all of the examples that the description of the second polyesters as being crosslinked and/or non-linear is erroneous.

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**CONCLUSION**

Appellant has persuasively demonstrated that the rejections over 35 U.S.C. §112, first paragraph have been overcome. Therefore, any rejection disregarding the limitations previously asserted to be new matter should also be overcome.

If this paper is not timely filed, appellants hereby petition for an appropriate extension of time. The fee for any such extension and any other fees that may be required to effect consideration of this paper may be charged to Deposit Account No. 50-2866.

Respectfully submitted,

**WESTERMAN, HATTORI, DANIELS & ADRIAN, LLP**

  
Kenneth H. Salen

Attorney for Appellant  
Registration No. 43,077  
Telephone: (202) 822-1100  
Facsimile: (202) 822-1111

KHS/rf

### **VIII. CLAIMS APPENDIX**

The claims on appeal are 1, 3-5, 7, 9-11, 13, 14 and 18-22, and read as follows:

Claims 6, 8, 12, 15-17. (Canceled)

1. (Previously Presented) An imaging color toner comprising at least a binder resin, a colorant and an infrared absorber, wherein

the binder resin contains, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;

the first polyester resin is a crosslinked polyester resin having a softening point Tsp of not lower than 120°C and lower than 170°C, and also contains 1 to 25 parts by weight of a chloroform-insoluble content as the component; and

the second polyester resin is a non-crosslinked polyester resin having a softening point Tsp of not lower than 80°C and lower than 110°C, wherein the toner is capable of being photofixed; and

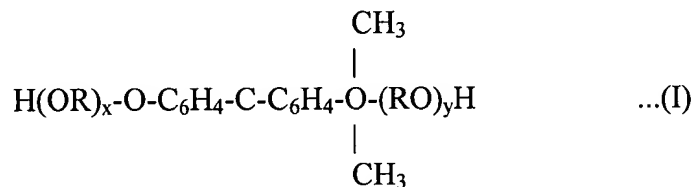
wherein an acid value of the first polyester resin is from 20 to 40, an acid value of the second polyester resin is from 5 to 20, and an acid value of the entire polyester resin is from 15 to 35.

2. (Canceled)

3. (Previously Presented) The imaging color toner according to claim 1, wherein the infrared absorber is a compound which shows a light absorption peak at a wavelength ranging from 700 to 1000 nm.

4. (Original) The imaging color toner according to claim 3, wherein the infrared absorber is at least one compound selected from the group consisting of cyanine, anthraquinone, phthalocyanine, naphthalocyanine, polymethine, nickel complex, aminium, diimonium, tin oxide, ytterbium oxide, ytterbium phosphate, and cerium oxide.

5. (Previously Presented) The imaging color toner according to claim 1, wherein the first polyester resin is a polyester resin originating from an alkylene oxide adduct of bisphenol A represented by the following formula (I):



wherein R represents a substituted or unsubstituted alkyl group, and x and y each represents an integer of 1 or more.

7. (Previously Presented) A method of forming a color image on a recording medium which comprises the steps of forming an electrostatic latent image by image exposure, visualizing the electrostatic latent image by development, transferring the visualized image onto the recording medium and fixing the transferred image, wherein

a developing agent comprising a color toner, which comprises at least a binder resin, a colorant and an infrared absorber, is used in the step of developing the electrostatic latent image,

the binder resin containing, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;

the first polyester resin being a crosslinked polyester resin having a softening point T<sub>sp</sub> of not lower than 120°C and lower than 170°C, and also containing 1 to 25 parts by weight of a chloroform insoluble content as the component; and



the second polyester resin being a polyester resin having a softening point Tsp of not lower than 80°C and lower than 110°C, said second polyester resin being a polymerization product of polyoxypropylene (2.2)-2, 2-bis (4-hydroxyphenyl) propane, polyoxyethylene (2.2)-2, 2-bis (4-hydroxyphenyl) propane and terephthalic acid in the absence of a crosslinking component; and

a photofixing system is used at a light emission energy density ranging from 1.0 to 6.0 J/cm<sup>2</sup> in the step of fixing the transferred image after transferring the image visualized by using the developing agent onto the recording medium;

wherein an acid value of the first polyester resin is from 20 to 40, an acid value of the second polyester resin is from 5 to 20, and an acid value of the entire polyester resin is from 15 to 35.

9. (Previously Presented) The color image forming method according to claim 7, wherein the infrared absorber is a compound which shows a light absorption peak at a wavelength ranging from 700 to 1000 nm.

10. (Original) The color image forming method according to claim 9, wherein the infrared absorber is at least one compound selected from the group consisting of cyanine, anthraquinone, phthalocyanine, naphthalocyanine, naphthalocyanine, polymethine, nickel complex, aminium, diimonium, tin oxide, ytterbium oxide, ytterbium phosphate, and cerium oxide.

11. (Previously Presented) An apparatus for forming a color image on a recording medium comprising an image exposing device for forming an electrostatic latent image, a developing device for visualizing the electrostatic latent image, an image transferring device for transferring the visualized image onto the recording medium, and an imaging fixing device for fixing the transferred image onto the recording medium, wherein

the developing device is loaded with a developing agent containing a color toner, which comprises at least a binder resin, a colorant and an infrared absorber,

the binder resin containing, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;

the first polyester resin being a crosslinked polyester resin having a softening point Tsp of not lower than 120°C and lower than 170°C, and also containing 1 to 25 parts by weight of a chloroform-insoluble content as the component; and

the second polyester resin being a polyester resin having a softening point Tsp of not lower than 80°C and lower than 110°C, said second polyester resin being a polymerization product of polyoxypropylene (2.2)-2, 2-bis (4-hydroxyphenyl) propane, polyoxyethylene (2.2)-2, 2-bis (4-hydroxyphenyl) propane and terephthalic acid in the absence of a crosslinking component; and

the image fixing device being provided with a photofixing device having a light emission energy density ranging from 1.0 to 6.0 J/cm<sup>2</sup>;

wherein an acid value of the first polyester resin is from 20 to 40, an acid value of the second polyester resin is from 5 to 20, and an acid value of the entire polyester resin is from 15 to 35.

13. (Previously Presented) The color image forming apparatus according to claim 11, wherein the infrared absorber is a compound which shows a light absorption peak at a wavelength ranging from 700 to 1000 nm.

14. (Original) The color image forming apparatus according to claim 13, wherein the infrared absorber is at least one compound selected from the group consisting of cyanine, anthraquinone, phthalocyanine, naphthalocyanine, polymethine, nickel complex, aminium, diimonium, tin oxide, ytterbium oxide, ytterbium phosphate, and cerium oxide.

18. (Previously Presented) The imaging color toner according to claim 1, wherein said second polyester resin is a polymerization product of polyoxypropylene (2.2) -2, 2-bis (4-hydroxyphenyl) propane, polyoxyethylene (2.2) -2, 2-bis (4-hydroxyphenyl) propane and terephthalic acid in the absence of a crosslinking component.

19. (Previously Presented) An imaging color toner comprising at least a binder resin, a colorant and an infrared absorber, wherein;

the binder resin contains, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;

the first polyester resin is a crosslinked polyester resin having a softening point Tsp of not lower than 120 °C and lower than 170 °C, and also contains 1 to 25 parts by weight of a chloroform-insoluble content as the component; and

the second polyester resin is a non-crosslinked polyester resin having a softening point Tsp of 110 °C, wherein the toner is capable of being photofixed; and

wherein an acid value of the first polyester resin is from 20 to 40, an acid value of the second polyester resin is from 5 to 20, and an acid value of the entire polyester resin is from 15 to 35.

20. (Previously Presented) An imaging color toner comprising at least a binder resin, a colorant and an infrared absorber, wherein;

the binder resin contains, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;

the first polyester resin is a crosslinked polyester resin having a softening point Tsp of not lower than 120 °C and lower than 170 °C, and also contains 1 to 25 parts by weight of a chloroform-insoluble content as the component; and

the second polyester resin is a linear polyester resin having a softening point Tsp of not lower than 80 °C and lower than 110 °C, wherein the toner is capable of being photofixed;

and wherein an acid value of the first polyester resin is from 20 to 40, an acid value of the second polyester resin is from 5 to 20, and an acid value of the entire polyester resin is from 15 to 35.

21. (Previously Presented) The imaging color toner according to claim 20, wherein said second polyester resin is a polymerization product of polyoxypropylene (2.2)-2, 2-bis (4-hydroxyphenyl) propane, polyoxyethylene (2.2) -2,2-bis (4-hydroxyphenyl) propane and terephthalic acid in the absence of a crosslinking component.

22. (Previously Presented) An imaging color toner comprising at least a binder resin, a colorant and an infrared absorber, wherein;

the binder resin contains, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;

the first polyester resin is a crosslinked polyester resin having a softening point Tsp of not lower than 120 °C and lower than 170 °C, and also contains 1 to 25 parts by weight of a chloroform-insoluble content as the component; and

the second polyester resin is a linear polyester resin having a softening point Tsp of 110 °C, wherein the toner is capable of being photofixed; and

wherein an acid value of the first polyester resin is from 20 to 40, an acid value of the second polyester resin is from 5 to 20, and an acid value of the entire polyester resin is from 15 to 35.

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**IX. EVIDENCE APPENDIX**

Declaration of Dr. Masatoshi KIMURA dated August 5, 2003.

Translator's Declaration of Keizo KOMORIYA dated July 25, 2003

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**(X) RELATED PROCEEDINGS APPENDIX**

Not applicable.



THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re the Application of: Yasushige Nakamura et al.

Serial No.: 09/935,668      Group Art Unit: 1756

Filed: August 24, 2001      Examiner: Dote, Janis L.

For: IMAGING COLOR TONER, COLOR IMAGE FORMING METHOD AND  
COLOR IMAGE FORMING APPARATUSDECLARATION UNDER 37 C.F.R. 1.132

Commissioner for Patents

Washington, D.C. 20231

Sir:

I, Masatoshi Kimura, a citizen of Japan, residing at C/O  
Fuji Xerox Co., Ltd.; 2274, Hongo, Ebina-shi, Kanagawa  
243-0494, Japan, declare and state the following:

(1) That I graduated from Okayama University, Faculty  
of Engineering, Department of Electronic Engineering, in  
1973,

completed a master course of Osaka University,  
Graduate school of Engineering, Department of Electronic  
Engineering, in 1975,

joined Fujitsu Laboratories Ltd. (Kanagawa) in 1975,

was transferred from Fujitsu Laboratories Ltd. to Fujitsu Limited (Kanagawa), and

changed from Fujitsu Limited to Fuji Xerox Co., Ltd. (Kanagawa);

(2) That I was and am engaged in research and development of an electrostatic recording process and an electrophotographic process in Fujitsu Laboratories Ltd., Fujitsu Limited and Fuji Xerox Co., Ltd.;

(3) That I have a doctorate in Engineering and am a director of The Imaging Society of Japan (ISJ), Tokyo;

(4) That I fully understand the Japanese and English languages;

(5) That I have read the English language specification of the present application and its Japanese counterpart, Japanese Language specification of Japanese Patent Application No. 2001-101159, filed March 30, 2001;

(6) That I noted the readily apparent misuse of the



"second, non-linear polyester" in the specification and appended claims of the present application;

(7) That it was readily apparent to the Declarant from the disclosure of the specification that "second, non-linear polyester" should be revised to the intended meaning "second, linear [non-linear] polyester" because:

(a) There is a logical incongruity between the first, non-linear polyester "and the second, non-linear polyester", since these two polyesters must have different structures and properties to attain the intended synergistic effects in the resulting toner as is apparent to a person skilled in the art from the context of the specification, for example, page 10, lines 3 to 25 of the specification.

(b) Generally, the term "non-linear polyester" means a polyester resin containing a three-dimensionally crosslinked component (gel component), whereas "linear polyester" means a polyester resin containing no crosslinked component. Referring to Table 1 on page 24 of the specification, "polyesters 1-1 to 1-5" contain trimellitic acid as a crosslinking component and thus contain a produced chloroform insoluble in an amount of 0.5 to 30%. These features evidence that the first polyester is a non-linear polyester. On the other hand, the second polyesters

("polyesters 2-1 to 2-5") do not contain a crosslinking component and thus contain no chloroform insoluble produced. These features evidence that the second polyester is a linear polyester. It is therefore apparent that the inventors of this application have described the second polyester in error to be a non-linear polyester.

(c) Paragraph 0021 of the Japanese language specification of Japanese Patent Application No. 2001-101159, as the Examiner can see from the English language translation thereof, prepared and sworn by Mr. Keizo Komoriya of A. Aoki, Ishida & Associates, discloses as follows:

--The first polyester resin is a non-linear polyester resin containing a tri- or polyvalent monomer, and also has a comparatively high molecular weight, and thus exhibits excellent void resistance, but is not easily fixed by means of low light emission energy. On the other hand, the second polyester resin is a linear polyester resin and can have excellent low energy fixability. However, the second polyester resin is inferior in void resistance because of its low viscosity.--

This evidences that the recitation of the second non-linear polyester in the specification and appended claims of this application was made in error.

The undersigned declares that all statements made herein of his own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements are punishable by fine or imprisonment or both under §1001 of Title 18 of the United States Code, and that willful false statements may jeopardize the validity of the application or any patent issued thereon.

Signed this                      5th day of August                      , 2003.

*Masatoshi Kimura*

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Masatoshi Kimura

In re Patent Application of: Yasushiye Nakamura et al.

Serial No. 09/935,668

Examiner: DOTE, JANIS L

Filed: August 24, 2001

Group Art Unit: 1756

For: IMAGING COLOR TONER, COLOR IMAGE FORMING METHOD AND COLOR  
IMAGE FORMING APPARATUS

TRANSLATOR'S DECLARATION

Honorable Commissioner of Patents & Trademarks  
Washington, D.C. 20231

Sir:

I, Keizo Komoriya, residing at c/o A. AOKI, ISHIDA  
& ASSOCIATES, Toranomom 37 Mori Bldg., 3-5-1, Toranomom Minato-  
ku, Tokyo 105-8423, Japan declare the following:

(1) That I know well both the Japanese and English  
languages;

(2) That I translated Japanese Patent Application  
No. 2001-101159, filed March 30, 2001, from the Japanese  
language to the English language;

(3) That the attached English translation is a true and  
correct translation of the aforesaid Japanese Patent  
Application No. 2001-101159 to the best of my knowledge and  
belief; and

(4) That all statements made of my own knowledge are true  
and that all statements made on information and belief are  
believed to be true, and further that these statements are made  
with the knowledge that willful false statements and the like  
are punishable by fine or imprisonment, or both, under  
18 U.S.C. 1001, and that such false statements may jeopardize  
the validity of the application or any patent issuing thereon.

July 25, 2003

Date

Keizo Komoriya

Translator Keizo Komoriya

2001-101159(J162)

[NAME OF DOCUMENT] APPLICATION FOR PATENT

[REFERENCE NUMBER] 0150347

[DATE FILED] March 30, 2001

[DESTINATION] To Commissioner, Patent Office;  
Mr. Kozo Oikawa

[INTERNATIONAL PATENT CLASSIFICATION] G03G 9/087  
G03G 13/20  
G03G 15/20

[TITLE OF THE INVENTION] ELECTROPHOTOGRAPHIC COLOR  
TONER, COLOR IMAGE FORMING  
METHOD AND COLOR IMAGE FORMING  
APPARATUS

[NUMBER OF CLAIMS] 5

[INVENTOR]  
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[NAME OF DOCUMENT] Specification

[TITLE OF THE INVENTION] Electrophotographic Color Toner,  
Color Image Forming Method and Color Image Forming Apparatus  
[SCOPE OF CLAIM FOR PATENT]

[Claim 1] An electrophotographic color toner comprising  
at least a binder resin, a colorant and an infrared absorber,  
which is used in electrophotography employing a photofixing  
system, wherein

the binder resin contains, as a principal component, a  
polyester resin obtained by mixing a first polyester resin  
with a second polyester resin in a weight ratio of 80:20 to  
20:80;

the first polyester resin is a non-linear polyester resin  
having a softening point Tsp of not lower than 120°C and lower  
than 170°C, and contains 1 to 25 parts by weight of a  
chloroform-insoluble content as a component thereof; and

the second polyester resin is a ~~non-linear~~ polyester  
resin having a softening point Tsp of not lower than 80°C and  
lower than 110°C.

[Claim 2] The electrophotographic color toner according  
to claim 1, wherein an acid value of the first polyester resin  
is from 20 to 40, an acid value of the second polyester resin  
is from 5 to 20, and an acid value of the entire polyester  
resin is from 15 to 35.

[Claim 3] The electrophotographic color toner according  
to claim 1 or 2, wherein the infrared absorber is a compound  
which shows a light absorption peak at a wavelength ranging  
from 700 to 1000 nm.

[Claim 4] A method of forming a color image on a  
recording medium by means of an electrophotographic system  
which comprises the steps of forming an electrostatic latent  
image by image exposure, visualizing the electrostatic latent



image by development, transferring the visualized image onto the recording medium and fixing the transferred image, wherein in the step of developing the electrostatic latent image

a developing agent containing a color toner, which comprises at least a binder resin, a colorant and an infrared absorber,

the binder resin containing, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;

the first polyester resin being a non-linear polyester resin having a softening point Tsp of not lower than 120°C and lower than 170°C, and containing 1 to 25 parts by weight of a chloroform-insoluble content as a component thereof; and

the second polyester resin being a non-linear polyester resin having a softening point Tsp of not lower than 80°C and lower than 110°C, is used; and

a photofixing system is used at a light emission energy density ranging from 1.0 to 6.0 J/cm<sup>2</sup> in the step of fixing the transferred image after transferring the image visualized by using the developing agent onto the recording medium.

[Claim 5] An apparatus for forming a color image on a recording medium by means of an electrophotographic system, comprising an image exposing device for forming an electrostatic latent image, a developing device for visualizing the electrostatic latent image, an image transferring device for transferring the visualized image onto the recording medium, and an image fixing device for fixing the transferred image onto the recording medium, wherein

the developing device is loaded with a developing agent containing a color toner, which comprises at least a binder resin, a colorant and an infrared absorber,

the binder resin containing, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to

20:80;

the first polyester resin being a non-linear polyester resin having a softening point Tsp of not lower than 120°C and lower than 170°C, and containing 1 to 25 parts by weight of a chloroform-insoluble content as a component thereof; and

the second polyester resin being a non-linear polyester resin having a softening point Tsp of not lower than 80°C and lower than 110°C; and

the image fixing device is provided with a photofixing device having a light emission energy density ranging from 1.0 to 6.0 J/cm<sup>2</sup>.

[DETAILED DESCRIPTION OF THE INVENTION

[0001]

[Technical Field of the Invention]

The present invention relates to an electrophotographic toner and, more particularly, to an electrophotographic color toner suited for use in electrophotography employing a photofixing system. The color toner of the present invention can be used advantageously as a developing agent in various imaging apparatuses employing the electrophotographic system, for example, electrophotographic copying machine, electrophotographic facsimile, electrophotographic printer and electrostatic printing machine. The present invention also relates to a color image forming method and a color image forming apparatus, which employ the electrophotographic color toner.

[0002]

[Prior Art]

The electrophotographic system which has been widely used in copying machines, printers and printing machines generally begin by charging the surface of a photoconductive insulator such as a photosensitive drum uniformly with positive or negative electrostatic charge. After charging uniformly, the electrostatic charge on the insulating material is partially erased by irradiating the photoconductive insulator with light

image by various means thereby to form an electrostatic latent image. For example, an electrostatic latent image corresponding to image information can be formed on the photoconductive insulator by erasing the surface charge from particular portions by irradiating with a laser beam. Then a fine powder of developing agent referred to as toner is caused to deposit on the latent image where the electrostatic charge remains on the photoconductive insulator, thereby to visualize the latent image. Last, in order to print the toner image obtained as described above, it is common to electrostatically transfer the image onto a recording medium such as recording paper. For the fixation of the transferred toner image, such methods as a fixing method wherein toner is molten by pressurization, heating or combination thereof and is then solidified or a fixing method wherein toner is molten by irradiating with light and is then solidified have been employed, while much interest it being directed to a method referred to as a photofixing method (also referred to as a flash fixing method) which uses light that is free from adverse effects of pressurization and heating. In the photofixing method, since it is not necessary to apply a pressure to the toner during fixation, the need to bring the toner into contact (pressurization) with a fixing roller or the like is eliminated, and such an advantage is provided as imaging resolution (reproducibility) experiences less degradation in the fixing step. Also because it is not necessary to heat the toner with a heat source, the idle time before printing can be started after turning on the power to preheat the heating medium (fixing roller or the like) to a predetermined temperature is eliminated, so that printing can be started just upon turning on the power. Eliminating the need for a high temperature heat source has another advantage that the temperature in the apparatus does not rise too high. It also eliminates such a danger that the recording paper gets fire due to the heat generated by the heat source, even when the recording paper jams in the fixing device due to a system

breakdown or other trouble.

[0003]

However, a color toner has a low efficiency of absorbing light and, when the photofixing method is applied to the fixation of color toner, the fixability is lower than that in the case of fixing a black toner. Thus it has been proposed to improve the fixability by adding an infrared absorbing agent to the color toner, and many patent applications related to this technology have been laid-open as: Japanese Unexamined Patent Publication (Kokai) Nos. 60-63545, 60-63546, 60-57858, 60-57857, 58-102248, 50-102247, 60-131544, 60-133460 and 61-132959, WO99/13382, and Japanese Unexamined Patent Publication (Kokai) Nos. 2000-147824, 7-191492, 2000-155439, 6-348056, 10-39535, 2000-35689, 11-38666, 11-125930, 11-125928, 11-125929 and 11-65167. Technologies disclosed in these publications are attempts of making color rendering and photofixability compatible with each other by adding an infrared absorbing agent to the toner. However, any of the infrared absorbing agents proposed has the problem of inability to achieve satisfactory fixation.

[0004]

Moreover, the photofixing method has such a problem that the air in the vicinity of toner expands and the toner boils resulting in voids (central whitening defects) which are minute printing defects, because the toner is subjected to instantaneous heating by the irradiation with flashlight in the photofixing method. To address this problem, Japanese Unexamined Patent Publication (Kokai) No. 5-107805 discloses an attempt to prevent voids from occurring by controlling the softening point, the glass transition point and the acid value of a binder resin which is used as a major component of toner. However, this method is not effective in preventing voids from occurring when a color toner is used. In the case of a color toner, the binder resin is designed to have lower viscosity than that of the case of black toner for the purpose of smoothing the toner image, which leads to the generation of

voids.

[0005]

Moreover, Japanese Unexamined Patent Publication (Kokai) No. 4-338973 proposes to use a mixture of two kinds of binder resins as the binder resin. However, this method cannot simultaneously satisfy flash fixability and void resistance.

[0006]

[Problems to be Solved by the Invention]

Under these circumstances, the present invention has been made and an object thereof is to provide an electrophotographic color toner which allows it to use the photofixing system for fixing images, and is capable of improving both color toner fixability and void resistance in photofixation to the level of a monochromatic toner.

[0007]

Another object of the present invention is to provide a color image forming method which allows it to use the photofixing system for fixing images, and is capable of improving both color toner fixability and void resistance in photofixation to the level of a monochromatic toner.

Still another object of the present invention is to provide a color image forming apparatus which allows it to use the photofixing system for fixing images, and is capable of improving both color toner fixability and void resistance in photofixation to the level of a monochromatic toner.

[0008]

The objects described above and other objects of the present invention will become apparent from the following detailed description.

[0009]

[Means for Solving the Problems]

An aspect of the present invention is an electrophotographic color toner comprising at least a binder resin, a colorant and an infrared absorber, which is used in electrophotography employing a photofixing system, wherein the binder resin contains, as a principal component, a

polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;

the first polyester resin is a non-linear polyester resin having a softening point  $T_{sp}$  of not lower than 120°C and lower than 170°C, and contains 1 to 25 parts by weight of a chloroform-insoluble content as a component thereof; and

the second polyester resin is a non-linear polyester resin having a softening point  $T_{sp}$  of not lower than 80°C and lower than 110°C.

[0010]

Another aspect of the present invention is a method of forming a color image on a recording medium by means of an electrophotographic system which comprises the steps of forming an electrostatic latent image by image exposure, visualizing the electrostatic latent image by development, transferring the visualized image onto the recording medium and fixing the transferred image, wherein

a developing agent containing the color toner of the present invention is used in the step of developing the electrostatic latent image, and

a photofixing system is used at a light emission energy density ranging from 1.0 to 6.0 J/cm<sup>2</sup> in the step of fixing the transferred image after transferring the image visualized by using the developing agent onto the recording medium.

[0011]

Furthermore, still another aspect of the present invention is an apparatus for forming a color image on a recording medium by means of an electrophotographic system, comprising an image exposing device for forming an electrostatic latent image, a developing device for visualizing the electrostatic latent image, an image transferring device for transferring the visualized image onto the recording medium, and an image fixing device for fixing the transferred image onto the recording medium, wherein

the developing device is loaded with a developing agent containing the color toner of the present invention, and the image fixing device is provided with a photofixing device having a light emission energy density ranging from 1.0 to 6.0 J/cm<sup>2</sup>.

[0012]

[Embodiments for Carrying out the Invention]

The present invention can be basically applied to common electrophotographic processes, not limited to a particular type of electrophotographic process. There is also no limitation to the developing method used in the electrophotographic process wherein the present invention is applied, and a proper developing method can be freely selected and employed for each application. In other words, according to the present invention, a developing agent most suitable for the developing method to be employed can be prepared and used for the particular application, while satisfying the requirements for the color toner of the present invention. Developing methods which can be employed in the present invention include both two-component developing system and one-component developing system that are widely used in the art.

[0013]

In the two-component developing system, toner particles and carrier particles, such that comprise magnetite, ferrite, iron powder, glass beads or such particles coated with a resin, are brought into contact with each other, with the toner being caused to deposit on the carrier particles by the use of friction charging, and the toner is directed to a portion of latent image thereby to develop the image. In this system, a developing agent is constituted by combining the toner and the carrier. The particle diameter of the carrier is typically within a range from 30 to 500  $\mu$ m, while 0.5 to 10 % by weight of the toner particles is mixed with the carrier particles. Methods employed in this system include magnetic brush development method.

[0014]

The one-component developing system is also well known which is a variation of the two-component developing system wherein use of the carrier is eliminated. This method eliminates the need for mechanisms such as for toner concentration control, mixing and stirring because the carrier is not used, and also makes it possible to reduce the apparatus in size. In the one-component developing system, a thin uniform film of toner is formed on a developing roller which is made of a metal and an image is developed by attracting the toner to a portion of latent image. The toner particles deposited on the developing roller can be electrostatically charged by friction charging or electrostatic induction. In the case of one-component developing system employing friction charging, for example, a magnetic toner is used in BMT system and FEED system which involve contact, and nonmagnetic toner is used in touchdown system which involves contact. Details on the electrophotographic processes and the developing methods employed therein will be left to many publications dealing with the subject of electrophotographic system.

[0015]

The electrophotographic color toner of the present invention may have a composition similar to that of the color toner used in the electrophotographic system of the prior art. That is, the color toner of the present invention may be generally constituted so as to include at least a binder resin, a colorant and an infrared absorber. While various developing methods are employed in the electrophotographic system as described above, the color toner of the present invention may be either a magnetic toner which has magnetism by itself or a nonmagnetic toner depending on the developing method employed in the intended electrophotographic processes.

[0016]

As described above, the binder resin used as the base material in the electrophotographic color toner of the present



invention has the following essential constituent features:

- (1) the binder resin contains, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;
- (2) the first polyester resin is a non-linear polyester resin having a softening point Tsp of not lower than 120°C and lower than 170°C, and contains 1 to 25 parts by weight of a chloroform-insoluble content as a component thereof; and
- (3) the second polyester resin is a non-linear polyester resin having a softening point Tsp of not lower than 80°C and lower than 110°C, thereby making the color toner fixability and void resistance in photofixation compatible with each other, while remarkably improving them.

[0017]

The first polyester resin is a non-linear polyester resin having a softening point Tsp of not lower than 120°C and lower than 170°C. When the softening point Tsp of the polyester resin is 170°C or higher, low energy fixability is lowered. On the other hand, when the softening point Tsp of the polyester resin is 120°C or lower, the void resistance is lowered.

The second polyester resin is a non-linear polyester resin having a softening point Tsp of not lower than 80°C and lower than 110°C. When the softening point Tsp of the polyester resin is 110°C or higher, low energy fixability is lowered. On the other hand, when the softening point Tsp of the polyester resin is 80°C or lower, the void resistance and blocking resistance are lowered.

[0018]

Also the first polyester resin contains a chloroform-insoluble content as the component in the amount of not less than 1 part by weight and not more than 25 parts by weight.

When the chloroform-insoluble content exceeds 25 parts by weight, low energy fixability is deteriorated. On the other hand, when the chloroform-insoluble content is not more than 1 part by weight, voids are liable to occur.

The mixing ratio of the first polyester resin to the second polyester resin is preferably within a range from 80:20 to 20:80, and particularly preferably from 65:35 to 35:65. When the proportion of the first polyester resin is larger than the above range, low energy fixability tends to be lowered. On the other hand, when the proportion of the first polyester resin is smaller than the above range, the void resistance tends to be lowered.

[0019]

It is preferred that an acid value of the first polyester resin is from 20 to 40, an acid value of the second polyester resin is from 5 to 20, and an acid value of the entire polyester resin is from 15 to 35.

In addition to physical properties described above, the first and second polyester resins used as the binder resin preferably have a glass transition point  $T_g$  of 45°C or higher. Consequently, excellent blocking resistance can be obtained.

[0020]

Furthermore, the first and second polyester resins may have various molecular weights according to the desired effect. Usually, the first polyester resin has a comparatively high molecular weight (weight-average molecular weight) of about  $5 \times 10^3$  to  $5 \times 10^5$  (excluding a gel component). Usually, the second polyester resin has a comparatively low molecular weight of about  $1 \times 10^2$  to  $1 \times 10^4$ . Furthermore, the molecular weight of the entire polyester resin is usually within a range from  $1 \times 10^3$  to  $5 \times 10^4$ . When the molecular weight of the polyester resin drastically deviates from the range described above, disadvantages such as poor fixation and occurrence of voids are likely to occur.

[0021]

In the color toner of the present invention, the first and second polyester resins are mixed in a predetermined weight ratio and the resulting mixture of the polyester resins is used as a principal component of the binder resin. The reason is as follows.

The first polyester resin is a non-linear polyester resin containing a tri- or polyvalent monomer, and also has a comparatively high molecular weight, and thus exhibits excellent void resistance, but is not easily fixed by means of low light emission energy. On the other hand, the second polyester resin is a ~~linear polyester resin~~ and can have excellent low energy fixability. However, the second polyester resin is inferior in void resistance because of its low viscosity. The present inventors have taken notice of this fact and found the followings. That is, when using the first or second polyester resin alone, drawbacks of each polyester resin drastically appear. However, when using the first and second polyester resins in combination, like the color toner composition of the present invention, the synergy effect of merits of the first and second polyester resins can achieve excellent flash fixability without causing voids. Even if either of polyester resins is used alone, a binder resin capable of simultaneously satisfying the flash fixability and void resistance can not be synthesized. Furthermore, it is simpler to separately prepare binder resins and blending them, like the present invention.

[0022]

The first and second polyester resins can be respectively synthesized from a starting material which is generally used in the preparation of the polyester resin using a conventional procedure. Each polyester resin is not specifically limited, but can be preferably synthesized in the following manner.

[0023]

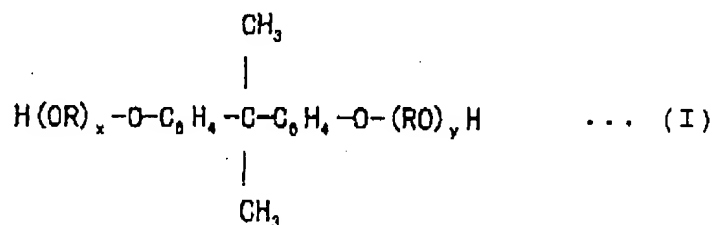
Examples of the acid component used in the synthesis of the polyester resin include, but are not limited to, terephthalic acid, isophthalic acid, ortho-phthalic acid, and

an anhydride thereof. Terephthalic acid and isophthalic acid are particularly preferred as the acid component. These acid components may be used alone or in combination. Other components can be used in combination with the compounds described above as far as odor does not become a problem during the flash fixation. Examples of preferred acid component to be used in combination include maleic acid, fumaric acid, citraconic acid, itaconic acid, glutaconic acid, cyclohexanedicarboxylic acid, succinic acid, adipic acid, sebacic acid, azelaic acid and malonic acid. The acid component further includes, for example, alkyl- or alkenylsuccinic acid such as n-butylsuccinic acid, n-butenylsuccinic acid, isobutylsuccinic acid, isobutenylsuccinic acid, n-octylsuccinic acid, n-octenylsuccinic acid, n-dodecylsuccinic acid, n-dodecenylsuccinic acid, isododecenylsuccinic acid, or isododecenylsuccinic acid, or an anhydride or a lower alkyl ester of these acids, or the other dihydric carboxylic acid. To crosslink the first polyester resin, a tri- or polyhydric carboxylic acid can be used as the other acid component. Examples of the tri- or polyhydric carboxylic acid include 1,2,4-benzenetricarboxylic acid, 1,3,5-benzenetricarboxylic acid, other polycarboxylic acid, and an anhydride thereof.

[0024]

The polyester resin used as the binder resin preferably contains at least a polyester resin originating from an alkylene oxide adduct of bisphenol A represented by the following formula (I):

[0025]



[0026]

wherein R represents a substituted or non-substituted alkyl group, preferably an ethylene group or a propylene group, and x and y each represents an integer of 1 or more. In the polyester resin used in the present invention, preferably 80 mol% or more, more preferably 90 mol% or more, and most preferably 95 mol% of an alcohol component is made of the alkylene oxide adduct of bisphenol A. When the amount of the alkylene oxide adduct of bisphenol A is less than 80 mol%, the amount of the monomer, which relatively causes odor, increases and, therefore, it is not preferred.

[0027]

Examples of the alkylene oxide adduct of bisphenol A, which can be used as a raw material in the synthesis of the polyester resin, include polyoxypropylene(2.2)-2,2-bis(4-hydroxyphenyl)propane, polyoxypropylene(3.3)-2,2-bis(4-hydroxyphenyl)propane, polyoxyethylene(2.0)-2,2-bis(4-hydroxyphenyl)propane, polyoxyethylene(2.2)-2,2-bis(4-hydroxyphenyl)propane, polyoxypropylene(2.0)-polyoxyethylene(2.0)-2,2-bis(4-hydroxyphenyl)propane, and polyoxypropylene(6)-2,2-bis(4-hydroxyphenyl)propane. Among these compounds, polyoxypropylene(2.2)-2,2-bis(4-hydroxyphenyl)propane, polyoxyethylene(2.2)-2,2-bis(4-hydroxyphenyl)propane, and polyoxyethylene(2.0)-2,2-bis(4-hydroxyphenyl)propane can be used particularly advantageously. These compounds may be used alone or in combination.

[0028]

If necessary, other alcohol components can be used in combination with the compounds (alcohol components) described above. Examples of the other alcohol compounds include other dihydric alcohols, for example, diols (e.g. ethylene glycol, diethylene glycol, triethylene glycol, 1,2-propylene glycol, 1,3-propylene glycol, 1,4-butanediol, neopentyl glycol, 1,4-butanediol, 1,5-pentanediol, and 1,6-hexanediol), and bisphenol A and hydrogenated bisphenol A.

[0029]

Examples of the tri- or polyhydric alcohol component for synthesis of the first polyester resin include tri- or polyhydric alcohols, for example, sorbitol, 1,2,3,6-hexanetetrol, 1,4-sorbitan, pentaerythritol, dipentaerythritol, tripentaerythritol, 1,2,4-butanetriol, 1,2,5-pentanetriol, glycerol, 2-methylpropanetriol, 2-methyl-1,2,4-butanetriol, trimethylolethane, and trimethylolpropane. [0030]

In addition, esterification catalysts used commonly in the field of the synthesis of the resin to promote the reaction in the synthesis of the polyester resin, for example, zinc oxide, stannous oxide, dibutyltin oxide, and dibutyltin dilaurate can be used. The chloroform-insoluble content of the first polyester resin can be controlled to a desired level by preferably adding a tri- or polyhydric acid or alcohol component.

[0031]

The binder resin may further contain binders used commonly in the field of electrophotography, in addition to the polyester resins described above. Examples of the suitable binder resin, which can be optionally used, include styrene-acrylic resin, epoxy resin, and polyesterpolyol resin.

In the color toner of the present invention, the colorant to be dispersed in the binder resin includes various well-known dyes and pigments and can be arbitrarily selected and used. Preferred examples of the colorant include, but are not limited to, carbon black, lamp black, iron black, ultramarine blue, nigrosin dye, aniline blue, chalco oil blue, DuPont oil red, quinoline yellow, methylene blue chloride, phthalocyanine blue, phthalocyanine green, hansa yellow, rhodamine 6C lake, chrome yellow, quinacridon, benzidine yellow, malachite green, malachite green hexanoate, oil black, azo oil black, rose bengal, monoazo pigment, disazo pigment, and trisazo pigment. These colorants may be used alone, or used in combination to obtain a desired toner color.

[0032]

The content of the toner in the colorant can vary according to the desired results, but is usually within a range from 0.1 to 20 parts by weight, and preferably from 0.5 to 10 parts by weight, based on 100 parts by weight of the toner in view of the coloring force of printing, shape retention of the toner and scattering of the toner in order to obtain the best toner characteristics.

[0033]

As described above, it is essential to contain an infrared absorber, in addition to the binder resin and the colorant, in the electrophotographic color toner of the present invention. The infrared absorbing agent used in the present invention is preferably a compound which shows a light absorption peak at a wavelength ranging from 700 to 1000 nm, though it varies with the wavelength of flashlight used in photofixation. Preferred examples of the infrared absorber capable of showing the light absorption peak include cyanine, anthraquinone, phthalocyanine, naphthalocyanine, polymethine, nickel complex, aminium, diimonium, tin oxide, ytterbium oxide, ytterbium phosphate, and cerium oxide. These infrared absorbers may be used alone or, two or more infrared absorbers may be used in combination.

[0034]

The content of the infrared absorber in the toner can vary widely according to the desired results, but is preferably within a range from 0.01 to 10 parts by weight, and particularly preferably from 0.1 to 6 parts by weight, based on 100 parts by weight of the toner. When the amount of the infrared absorber is smaller than 0.01 parts by weight, the toner can not be fixed even in case of good design. On the other hand, the amount of the infrared absorber is larger than 10 parts by weight, the color of the color toner changes to brown, thus making it impossible to use the color toner.

[0035]

The electrophotographic color toner of the present invention can arbitrarily contain various conventional

additives.

For the purpose of improving the fluidity, the color toner of the present invention can be mixed with white fine inorganic powders. The amount of fine inorganic powders to be mixed with the toner is usually within a range from 0.01 to 5 parts by weight, and preferably from 0.01 to 2.0 parts by weight, based on 100 parts by weight of the toner. Examples of fine inorganic powders include fine powders of silica, titanium oxide, barium titanate, magnesium titanate, calcium titanate, strontium titanate, zinc oxide, silica sand, clay, mica, wollastonite, diatomaceous earth, chromium oxide, cerium oxide, red iron oxide, antimony trioxide, magnesium oxide, zirconium oxide, barium sulfate, barium carbonate, calcium carbonate, silicon carbide, and silicon nitride. Among these fine powders, fine silica powders are particularly preferred. Well-known materials such as silica, titanium, fine resin powders and alumina can be used in combination. As the cleaning active agent, for example, fine powders of metal salts of higher fatty acid (e.g. zinc stearate, etc.) and fluorine polymeric substances may be added.

[0036]

For the purpose of controlling the charge characteristics of the toner, charge controlling agents used commonly in this technical field can be used. Examples of the suitable charge controlling agent include nigrosine dye, quaternary ammonium salt, amino group-containing polymer, metal-containing azo dye, complex compound of salicylic acid, and phenol compound in case of positive charging. Among these charge controlling agents, quaternary ammonium salt, amino group-containing polymer and complex compound of salicylic acid, which do not exert an adverse influence on a color hue, are useful. In case of negative charging, azochrome compound, azo zinc compound and calixarene compound are used.

[0037]

Furthermore, well-known waxes such as polyethylene, polypropylene, ester wax, carnauba, Fisher-Tropsch wax,



paraffin wax, and rice wax can be additionally used.

The electrophotographic color toner of the present invention can be prepared according to various procedures using the toner components described above as the starting materials. For example, the color toner of the present invention can be made by employing a known method such as mechanical grinding and classifying process where resin blocks with a colorant or the like dispersed therein are ground and classified, or a polymerization method where a monomer is polymerized while mixing a colorant or the like therein thereby forming fine particles. The color toner of the present invention is preferably made by the mechanical grinding method, advantageously in a procedure as described below.

(1) Mixing of materials

A binder resin, a colorant, a charge controlling agent, an infrared absorber and the like are weighed and mixed uniformly in a powder mixing machine. For the powder mixing machine, for example, a ball mill or the like can be used. The colorant, the charge controlling agent, etc. are dispersed uniformly in the resin binder.

(2) Melt kneading

The mixture thus obtained is heated to melt and kneaded, by using a screw extruder (extruder), roll mill, kneader or the like. This turns the colorant particles into fine particles and causes the agents to be dispersed uniformly.

(3) Solidification with cooling

After the completion of the kneading, the kneaded mixture is solidified with cooling.

(4) Grinding

The solidified mixture is first ground into coarse particles with a coarse grinder such as hammer mill or cutter mill, and then ground into fine powder with a pulverizer such as jet mill.

(5) Classification

The fine powder made by fine grinding is classified so as

to remove particles which are too small and result in lower fluidity of the toner and scatter of the toner, and particles which are too larger and result in degradation of picture quality. For the classifier, for example, wind classifier that utilizes a centrifugal force may be used to obtain desired spherical fine particles of the toner.

(6) Surface treatment

In the last step, the toner particles may be coated with hydrophobic silica or titanium oxide, with another additive added as required, for the purpose of improving the fluidity of the toner. A high speed flow mixer may be used in the surface treatment.

[0038]

The color image forming method of the present invention includes the steps of forming an electrostatic latent image by image exposure, visualizing the electrostatic latent image by development, transferring the visualized image onto the recording medium and fixing the transferred image, as described previously, while a developing agent containing the color toner of the present invention is used, unlike a conventional method.

[0039]

Also according to the present invention, in the step of transferring the image which has been visualized by the use of the developing agent onto the recording medium and then fixing the image, the photofixing system is employed to fix the toner. Flashlight can be advantageously used in the photofixation of the transferred toner image. The flashlight may have wavelengths selected from a broad region reaching near infrared as well as the visible region, in accordance to the specifications of the flash fixing device to be used. A xenon lamp can be used to generate the flashlight which efficiently fix the toner. A light intensity of the xenon lamp is preferably within a range from 1.0 to 6.0 J/cm<sup>2</sup> in terms of energy density per unit area in a single flash. An energy density of light less than 1.0 J/cm<sup>2</sup> is unable to fix

the toner and an energy density higher than  $6.0 \text{ J/cm}^2$  may burn the paper, although formation of toner voids can be avoided. The energy density of light  $S \text{ J/cm}^2$  is given as follows.

[0040]

$$S = ((1/2) \times C \times V^2) / (u \times l) / (n \times f)$$

where  $n$  is the number of lamps,

$f$  is the lighting frequency (Hz),

$V$  is the input voltage,

$C$  is the capacitance of a capacitor ( $\mu\text{F}$ ),

$u$  is the traveling speed of the process (mm/s), and

$l$  is the printing width (mm).

Although duration of one flashing cycle of the flashlight may be set within a wide range according to the energy density of flashlight, it is preferably in a range from 500 to 3,000  $\mu\text{s}$ . Too short a flashing cycle of the flashlight may be unable to melt the toner sufficiently to increase the fixing rate. Too long a flashing cycle of the flashlight may, on the other hand, cause overheating of the toner which is fixed on the recording medium.

[0041]

More specifically, the color image forming method of the present invention may be applied similarly to the image forming method of the prior art, except for the difference described above. By way of a preferable example, formation of an electrostatic latent image by image exposure can be carried out, after uniformly charging the surface of a photoconductive insulator such as a photosensitive drum with positive or negative electrostatic charge, by partially erasing the electrostatic charge deposited on the insulator by irradiating the photoconductive insulator with light in the pattern of the image with any of various means, thereby leaving the electrostatic latent image to remain. For example, the surface charge can be erased from particular portions by irradiating with laser beam, so as to form the electrostatic latent image on the photoconductive insulator according to the

image information.

[0042]

Then the electrostatic latent image thus formed is visualized by development. This can be done by depositing the fine powder of the developing agent, which includes the toner of the present invention, on the latent image portion where the electrostatic charge remains on the photoconductive insulator.

After the developing step, the visualized image is transferred onto the recording medium. This can be generally done by electrostatically transferring the toner image onto the recording medium such as recording paper.

[0043]

Finally, the toner image transferred in the transfer step described above is molten and fixed on the recording medium by the flash fixing method according to the present invention. An intended duplicate (print or the like) is obtained through the series of processes described above.

The method of forming color images based on electrophotography is well known in this technical field and accordingly description thereof will be omitted herein.

[0044]

Similarly, the color image forming apparatus of the present invention, typically the electrophotographic apparatus, is also well known in this technical field and accordingly description thereof will be omitted herein. For reference, an example of electrophotographic apparatus which can be advantageously used in the present invention is shown in Fig. 1.

In the electrophotographic apparatus shown in Fig. 1, a developing agent 11 prepared by mixing the color toner of the present invention and a carrier is stirred with a stirring screw 12 so as to effect friction charging. The developing agent 11 which is charged by friction is guided through a predetermined circulation path via a developing roller 13 to reach a photosensitive drum 14. The photosensitive drum 14

may be constituted from a photosensitive material which has photoconductivity, for example organic photosensitive material such as polysilane, phthalocyanine, phthalopolymethine or inorganic photosensitive material such as selenium and amorphous silicon, or an insulating material, depending on the method of forming the latent image. A photosensitive material made of amorphous silicon is particularly preferable in view of long lifetime thereof.

[0045]

The surface of the photosensitive drum 14 which has received the developing agent 11 transferred thereto is electrostatically charged by a preliminary charger 15 located behind the drum in the rotating direction thereof, while the electrostatic latent image is formed thereon by the light applied by an exposure device (not shown) according to the image. The preliminary charger 15 may comprise a corona discharging mechanism such as corotron or scorotron, or a contact charging mechanism such as brush charger. The exposure device may be constituted by using various optical systems as the light source such as laser optical system, LED optical system or liquid crystal optical system. Thus the developing agent 11 which has been charged and transferred to the photosensitive drum 14 is deposited on the drum surface in the area of electrostatic latent image, thereby forming the visualized toner image.

[0046]

The toner image 11 formed on the photosensitive drum 14 is moved onto the transfer section 16 and is transferred onto a recording medium (paper, film, etc.) 21. The transfer section 16 may have various constitutions depending on the type of force used in the transfer process, such as electrostatic force, mechanical force or viscous force. In case electrostatic force is used, for example, corona transferring device, roll transferring device, belt transferring device or the like can be employed.

[0047]

The recording medium 21 is guided in the direction of arrow, so that the toner image is fixed thereon below the flash fixing device 18. The toner image on the recording medium 21 is heated by the flash fixing device 18 so as to melt and penetrate into the recording medium 21 thereby to be fixed. When the fixing step is completed, a fixed image 22 is obtained.

Toner which is left without being used in the transfer step in the toner image 11 on the photosensitive drum 14 is discharged by a decharger (not shown) and removed from the surface of the photosensitive drum 14 by a cleaning device (blade in the case shown in the drawing) 17. The cleaning device may be, besides the blade, magnetic brush cleaner, electrostatic brush cleaner or magnetic roller cleaner.

[0048]

#### [EXAMPLES]

The following examples further illustrate the present invention in detail. It goes without saying that the present invention is not limited to these examples.

#### Preparation Examples

##### (1) Preparation of polyester

An alcohol component, an acid component and a crosslinking component were prepared in accordance with the formulation shown in Table 1 below, and then charged in a 2 liter four-necked flask equipped with a thermometer, a stainless steel stirrer, a glass nitrogen introducing tube and a flow-down type condenser. The content in each flask was reacted in a mantle heater in a nitrogen gas flow under different reaction conditions (220°C or 240°C) for a predetermined time and the reaction was continued at the same temperature under reduced pressure of 60 mmHg for two hours. The softening point Tsp, the chloroform-insoluble content and the acid value of the resulting polyester (polyesters 1-1 to 1-5 and polyesters 2-1 to 2-5) were measured according to the following procedure. The results shown in Table 1 below were obtained.

<Softening point Tsp>

1 cm<sup>2</sup> of a sample was molten and flown-out under the conditions of a pore size of a die of 1 mm, a pressure of 20 kg/cm<sup>2</sup> and a heating rate of 6°C/minute, and then the temperature corresponding to half of the height from a flow-out starting point to a flow-out end point was measured by using a Koka-type flow tester "CFT-500" (manufactured by SHIMADZU CORPORATION) and taken as a softening point.

<Chloroform-insoluble content>

It refers to a content which does not penetrates through a filter paper after dissolving the sample in chloroform.

[0049]

The sample was finely ground and passed through a 40 mesh sieve. The resulting sample powder (5.00 g) was collected and put in a 150 ml container, together with 5.00 g of a filter aid Radiolite (#700). After pouring 100 g of chloroform into the container, the container was placed on a ball mill stand and rotated for five or more hours. The sample was sufficiently dissolved in chloroform.

On the other hand, a filter paper having a diameter of 7 cm (No. 2, weight has already measured) was placed in a pressure filter and 5.00 g of Radiolite was uniformly precoated thereon. After a small amount of chloroform was added, thereby to closely adhere a filter paper to the filter, the content in the container prepared in the previous step was poured into the filter. Furthermore, the container was sufficiently washed with 100 ml of chloroform and chloroform was poured into the filter so that deposits are not remained on the wall of the container. Then, a top cover of the filter was closed and the filtration was carried out. The filtration was carried out under pressure of 4 kg/cm<sup>2</sup> or less. After flow-out of chloroform was stopped, 100 ml of chloroform was further added, thereby to wash the residual substance on the filter paper, and the pressure filtration was carried out again. After the completion of the operations described above, the filter paper, the residue on thereon and Radiolite

were placed on an aluminum foil, put in a vacuum drier and then dried under the conditions of a temperature of 80 to 100°C and a pressure of 100 mmHg for 10 hours. The total weight  $a$  (g) of the dry solid thus obtained was measured and the chloroform-insoluble content  $x$  (% by weight) was determined by the following equation. The chloroform-insoluble content is a high-molecular polymer or a crosslinked polymer component in the polyester.

[0050]

$$x = [(a - \text{weight of filter paper}) - \text{weight of Radiolite}] / (\text{weight of sample}) \times 100$$

where the total weight of Radiolite is 10.00 g.

<Acid value>

It was measured according to the procedure defined in JIS K0070.

[0051]



Table 1

Polyester	Alcohol component		Acid component Terephthalic acid	Crosslinking component Trimellitic acid	Catalyst	Reaction conditions		Tsp (°C)	Chloroform-insoluble content (%)	Acid value (KOH mg/g)
	BPA-PO	BPA-EO				220°C	240°C			
Polyester 1-1	10 mol		9 mol	0.5 mol	DO	3 hours	-	110	0.5	10.5
Polyester 1-2	10 mol		11 mol	0.5 mol	DO	4 hours	-	120	1	21.5
Polyester 1-3	10 mol		12 mol	1 mol	DO	4 hours	3 hours	135	10	35.2
Polyester 1-4	10 mol		13 mol	1 mol	DO	4 hours	3 hours	170	25	44.2
Polyester 1-5	10 mol		10 mol	2 mol	DO	4 hours	3 hours	190	30	56.2
Polyester 2-1	5 mol	5 mol	10 mol	-	DO	2 hours		70	0	3.5
Polyester 2-2	5 mol	5 mol	11 mol	-	DO	3 hours		80	0	7.5
Polyester 2-3	5 mol	5 mol	12 mol	-	DO	3 hours	2 hours	100	0	10.6
Polyester 2-4	5 mol	5 mol	13 mol	-	DO	3 hours	3 hours	110	0	19.6
Polyester 2-5	5 mol	5 mol	14 mol	-	DO	4 hours	4 hours	120	0	30.5

BPA-PO: polyoxypropylene(2.2)-2,2-bis(4-hydroxyphenyl)propane

BPA-EO: polyoxyethylene(2.2)-2,2-bis(4-hydroxyphenyl)propane

DO: dibutyltin oxide

[0052]

(2) Preparation of polyester mixture

According to the formulation shown in Table 2 below, the polyesters 1-1 to 1-5 (first polyesters) and the polyesters 2-1 to 2-5 (second polyesters) were dry-mixed by using a mixer. As a result, polyesters A to P were obtained.

[0053]



Table 2

Polyester	Polyester A	Polyester B	Polyester C	Polyester D	Polyester E	Polyester F	Polyester G	Polyester H
	Proportion							
Polyester 1-1						50		
Polyester 1-2							50	
Polyester 1-3	10	20	50	80	90			
Polyester 1-4								50
Polyester 1-5								
Polyester 2-1								
Polyester 2-2								
Polyester 2-3	90	80	50	20	10	50	50	50
Polyester 2-4								
Polyester 2-5								

unit: parts by weight

[0054]

(3) Preparation of carrier

Magnetite particles 60  $\mu\text{m}$  in diameter to be used as the core of carrier particles were coated with an acrylic resin (BR-85 manufactured by Mitsubishi Rayon Co., Ltd.) in a fluidized bed and dried. The amount of the coating material is 2% by weight based on the amount of core material of the carrier. Magnetite carrier coated with the acrylic resin was thus obtained.

(4) Preparation of color toner

Color toners having different compositions shown in Table 4 and Table 5 were prepared. The infrared absorbing agents are summarized in Table 3.

Preparation of toner SCY-1

Components of the toner listed in Table 4 were prepared in each amount (parts by weight) described in Table 4. All the components of the material were charged in a Henschel mixer for preliminary mixing. Then the mixture was molten and kneaded in an extruder. After cooling the mixture to solidify, the solid mixture was ground by a hammer mill and then ground into fine powder in a jet mill. The fine powder thus obtained was classified by an air flow classifier, thereby to obtain fine particles colored in yellow having a volume-average particle diameter of 8.5  $\mu\text{m}$ . To the fine particles of toner thus obtained, 0.5 parts by weight of hydrophobic fine silica particles (H3004 manufactured by Clariant Japan Co., Ltd.) were externally added in the Henschel mixer.

Preparation of toner SCY-2 to SCY-24

In the same manner as in case of the preparation of the toner SCY-1, except that the materials and each amount thereof were changed to those described in Table 4 and Table 5 described below, toners SCY-2 to SCY-24 were prepared. After the colored fine particles having a volume-average particle diameter of 8.5  $\mu\text{m}$  were obtained, external additives were

added.

Examples 1 to 20 and Comparative Examples 1 to 9

Toner SCY-1 and toners SCY-2 to SCY-24 prepared as described above were used in printing tests employing the flash fixing system.

[0055]

5% by weight of each of the toners described above was mixed with 95% by weight of the carrier prepared as described above, thereby to make a developing agent. The developing agent was set in a high speed printing machine (PS2160 manufactured by Fujitsu Corp.) having a xenon lamp as the fixing light source. Then lines were printed at a process speed of 8,000 lines per m on plain paper used as the recording medium while changing the energy of fixing light as shown in Table 4 and Table 5. Light emitted by the xenon lamp as the spectrum schematically shown in Fig. 2, and the duration of one flash cycle was 1000  $\mu$ s. Prints thus obtained were evaluated for the following performance:

- (1) Fixation % of toner
- (2) Fixability
- (3) Occurrence of voids
- (4) Burning of paper
- (1) Measurement of fixation % of toner

The optical density (density of status A) of the lines printed on the paper was measured first. Then after lightly sticking an adhesive tape (Scotch™ Mending Tape manufactured by Sumitomo 3M) on the lines printed on the same paper, a cylinder made of steel 100mm in diameter and 20mm in width was rolled over the tape in contact therewith, and then the tape was pulled off the paper. Then, the optical density of the lines printed on the paper from which the tape was removed was measured again. Percentage of the optical density after removing the tape to the optical density before removing the tape (100%) was calculated and recorded as the fixation (%) of toner.

- (2) Fixability

The fixability of each toner was rated from the fixation (%) of the toner according to the following criteria.

[0056]

Below 70%	X
From 70% to below 80%	△
From 80% to below 90%	○
90% or higher	◎

Fixing rate of 80% or higher means that the toner has practically useful fixability.

(3) Evaluation of void (central whitening defect)

Lines printed on the paper were observed with an optical microscope, to visually determine whether central whitening defect was generated or not. Print without whitening defect was rated as ○, print having a little whitening defects which can be permitted in practice was rated as △, and print having white defects which are not practically permissible was rated as X.

(4) Evaluation of paper burning

It was visually checked to see whether or not the paper was burned in the print obtained first after continuous printing of million sheets. Print without paper burning was rated as ○, print having slight burning which can be permitted in practice was rated as △, and print having paper burning which was not practically permissible was rated as X.

[0057]

Table 2 (continued)

Polyester	Polyester	Polyester	Polyester	Polyester	Polyester	Polyester	Polyester	Polyester	Polyester
	I	J	K	L	M	N	P	Proportion	
Polyester 1-1									
Polyester 1-2						20			
Polyester 1-3		50	50	50	50				
Polyester 1-4							80		
Polyester 1-5	50								
Polyester 2-1		50							
Polyester 2-2			50			80			
Polyester 2-3	50								
Polyester 2-4				50			20		
Polyester 2-5					50				

unit: parts by weight

Table 3

Material	Article number	Manufacturer	Maximum absorption wavelength (nm)	Molecular absorption coefficient (ε)
Anthraquinone	IR-750	NIPPON KAYAKU CO., LTD.	755	17500
Polymethine	PS102	NIPPON KAYAKU CO., LTD.	820	167000
Cyanine	FT-10	NIPPON KAYAKU CO., LTD.	845	235000
Phthalocyanine	IR-3	NIPPON SHOKUBAI CO., LTD.	850	48000
Nickel complex	SIR-128	Mitsui Chemicals	855	60000
Naphthalocyanine	YKR-5010	Yamamoto Chemicals Inc.	880	91200
Aminium	IRG-005	NIPPON KAYAKU CO., LTD.	948	23900
Ytterbium oxide	UU-HP	SHIN-ETSU CHEMICAL CO., LTD.	980	-
Diimonium	IRG-023	NIPPON KAYAKU CO., LTD.	1090	105000
Tin oxide	TL30S	CATALYSTS&CHEMICALS IND.CO., LTD.	1095	-

{0059}



Table 4

Material	Name	Comp. Example 1	Example 1	Example 2	Example 3	Comp. Example 2	Comp. Example 3	Example 4	Example 5
Pigment	IRGALITE Yellow WSR (Ciba Speciality)	SCY-1	SCY-2	SCY-3	SCY-4	SCY-5	SCY-6	SCY-7	SCY-8
	Polyester A	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0
Binder	Polyester B	93.0	93.0						
	Polyester C			93.0					
	Polyester D				93.0				
	Polyester E					93.0			
	Polyester F								
	Polyester G						93.0		
	Polyester H							93.0	
	Polyester I								93.0
	Polyester J								
	Polyester K								
Charge controlling agent	Polyester L								
	Polyester M								
	Polyester N								
	Polyester P								
	CCA-100 (CHUO GOUSEI KAGAKU CO., LTD.)	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0
	IR-750								
	PS102								
	FT-10								
	IR-3								
	SIR-128								
Infrared absorber	YKR-5010	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5
	IRG-005								
	UU-HP								
	IRG-023								
	TL30S								
Max	NP105 (Mitsui Chemicals)	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5
External additive	H3004 (Clariant)	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5
Evaluation	Fixation (%)	95.0	92.0	90.0	85.0	62.0	93.0	91.0	85.0
	Judgment of fixability	⊙	⊙	⊙	⊙	×	⊙	⊙	⊙
	Occurrence of voids	×	⊙	⊙	⊙	⊙	×	⊙	⊙
	Paper burning	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙
	Photofixing energy (J/cm <sup>2</sup> )	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2

[0060]

Table 4 (continued)

Material	Name	Comp. Example 4	Comp. Example 5	Example 6	Example 7	Comp. Example 6	Example 8	Example 9
Pigment	IRGALITE Yellow WSR (Ciba Speciality)	SCY-9	SCY-10	SCY-11	SCY-12	SCY-13	SCY-14	SCY-15
	Polyester A	5.0	5.0	5.0	5.0	6.0	7.0	8.0
Binder	Polyester B							
	Polyester C							
	Polyester D							
	Polyester E							
	Polyester F							
	Polyester G							
	Polyester H							
	Polyester I	93.0						
	Polyester J		93.0					
	Polyester K			93.0				
	Polyester L				93.0			
	Polyester M					93.0		
Charge controlling agent	Polyester N						93.0	
	Polyester P							93.0
Infrared absorber	CCA-100 (CHUO GUSEI KAGAKU CO., LTD.)	1.0	1.0	1.0	1.0	1.0	1.0	1.0
	IR-750							
	PS102							
	FT-10							
	IR-3							
	SIR-128							
	YKR-5010	0.5	0.5	0.5	0.5	0.5	0.5	0.5
	IRG-005							
	UU-HP							
	IRG-023							
	TL30S							
Wax External additive	NPI05 (Mitsui Chemicals)	0.5	0.5	0.5	0.5	0.5	0.5	0.5
	H3004 (Clariant)	0.5	0.5	0.5	0.5	0.5	0.5	0.5
Evaluation	Fixation (%)	65.0	95.0	92.0	81.0	55.0	98.0	800
	Judgment of fixability	X	⊙	⊙	⊙	X	⊙	⊙
	Occurrence of voids	⊙	X	⊙	⊙	⊙	△	⊙
	Paper burning	⊙	⊙	⊙	⊙	⊙	⊙	⊙
	Photofixing energy (J/cm <sup>2</sup> )	2.2	2.2	2.2	2.2	2.2	2.2	2.2

[0061]

Table 5

Material	Name	Example 10	Example 11	Example 12	Example 13	Example 14	Example 15	Example 16	Example 17
Pigment	IRGALITE Yellow WSR (Ciba Speciality)	SCY-16	SCY-17	SCY-18	SCY-19	SCY-20	SCY-21	SCY-22	SCY-23
Binder	Polyester C	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0
CCA	CCA-100 (CHUO GOUSEI KAGAKU CO., LTD.)	93.0	93.0	93.0	93.0	93.0	93.0	93.0	93.0
	IR-750	1.0	1.0	1.0	1.0	1.0	1.0	1.0	1.0
	PS102	0.50							
	FT-10		0.50						
	IR-3			0.50					
Infrared absorber	SIR-12B					0.50			
	YKR-5010								
	IRG-005						0.5		
	UD-HP							0.5	
	IRG-023								0.5
	TL30S								
Wax	NP105 (Mitsui Chemicals)	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5
External additive	H3004 (Clariant)	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5
Evaluation	Fixation (%)	84.0	85.0	86.0	82.0	81.0	82.0	83.0	82.0
	Judgment of fixability	O	O	O	O	O	O	O	O
	Occurrence of voids	O	O	O	O	O	O	O	O
	Paper burning	O	O	O	O	O	O	O	O
	Photofixing energy (J/cm <sup>2</sup> )	2.2	2.2	2.2	2.2	2.2	2.2	2.2	2.2

[0062]

Table 5 (continued)

	Name	Example 18	Comp. Example 7	Example 19	Example 20	Example 21	Comp. Example 8	Comp. Example 9
Material	Pigment	IRGALITE Yellow WSR (Ciba Speciality)	SCY-24	SCY-3	SCY-3	SCY-3	SCY-3	SCY-3
	Binder	Polyester C	5.0	5.0	5.0	5.0	5.0	5.0
	CCA	CCA-100 (CHUO GOUSEI KAGAKU CO., LTD.)	93.0	93.0	93.0	93.0	93.0	93.5
	Infrared absorber	IR-750	1.0	1.0	1.0	1.0	1.0	1.0
		PS102						
		FT-10						
		IR-3						
		SIR-128						
		YKR-5010		0.50	0.50	0.50	0.50	
		IRG-005						
		UU-HP						
	Wax	IRG-023						
	External additive	TL30S	5.0					
		NP105 (Mitsui Chemicals)	0.5	0.5	0.5	0.5	0.5	0.5
		H3004 (Clariant)	0.5	0.5	0.5	0.5	0.5	0.5
Evaluation	Fixation (%)	80.0	65.0	85.0	98.0	99.0	100.0	15.0
	Judgment of fixability	○	×	○	⊙	⊙	⊙	×
	Occurrence of voids	○	○	○	○	△	×	○
	Paper burning	○	○	○	○	△	×	○
	Photofixing energy (J/cm <sup>2</sup> )	2.2	0.5	1.0	3.0	6.0	7.0	2.2

[0063]

Finally, preferred embodiments of the present invention will be described below for further understanding of the present invention.

(Appendix 1) An electrophotographic color toner comprising at least a binder resin, a colorant and an infrared absorber, which is used in electrophotography employing a photofixing system, wherein

the binder resin contains, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;

the first polyester resin is a non-linear polyester resin having a softening point Tsp of not lower than 120°C and lower than 170°C, and contains 1 to 25 parts by weight of a chloroform-insoluble content as a component thereof; and

the second polyester resin is a non-linear polyester resin having a softening point Tsp of not lower than 80°C and lower than 110°C.

[0064]

(Appendix 2) The electrophotographic color toner according to Appendix 1, wherein an acid value of the first polyester resin is from 20 to 40, an acid value of the second polyester resin is from 5 to 20, and an acid value of the entire polyester resin is from 15 to 35.

(Appendix 3) The electrophotographic color toner according to Appendix 1 or 2, wherein the infrared absorber is a compound which shows a light absorption peak at a wavelength ranging from 700 to 1000 nm.

[0065]

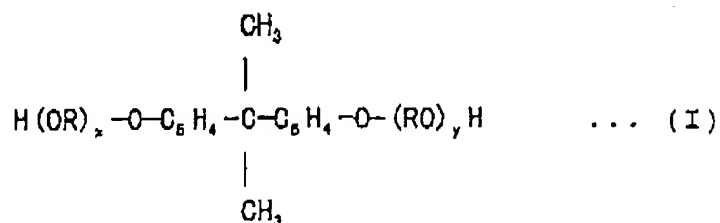
(Appendix 4) The electrophotographic color toner according to Appendix 3, wherein the infrared absorber is at least one compound selected from the group consisting of cyanine, anthraquinone, phthalocyanine, naphthalocyanine, polymethine, nickel complex, aminium, diimonium, tin oxide,

ytterbium oxide, ytterbium phosphate, and cerium oxide.

[0066]

(Appendix 5) The electrophotographic color toner according to any one of Appendixes 1 to 4, wherein the binder resin contains at least a polyester resin originating from an alkylene oxide adduct of bisphenol A represented by the following formula:

[0067]



[0068]

wherein R represents a substituted or non-substituted alkyl group, and x and y each represents an integer of 1 or more.

(Appendix 6) A method of forming a color image on a recording medium by means of an electrophotographic system which comprises the steps of forming an electrostatic latent image by image exposure, visualizing the electrostatic latent image by development, transferring the visualized image onto the recording medium and fixing the transferred image, wherein in the step of developing the electrostatic latent image

a developing agent containing a color toner, which comprises at least a binder resin, a colorant and an infrared absorber,

the binder resin containing, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;

the first polyester resin being a non-linear polyester resin having a softening point Tsp of not lower than 120°C and lower than 170°C, and containing 1 to 25 parts by weight of a chloroform-insoluble content as a component thereof; and

the second polyester resin being a non-linear polyester resin having a softening point Tsp of not lower than 80°C and lower than 110°C, is used; and

a photofixing system is used at a light emission energy density ranging from 1.0 to 6.0 J/cm<sup>2</sup> in the step of fixing the transferred image after transferring the image visualized by using the developing agent onto the recording medium.

[0069]

(Appendix 7) The color image forming method according to Appendix 6, wherein an acid value of the first polyester resin is from 20 to 40, an acid value of the second polyester resin is from 5 to 20, and an acid value of the entire polyester resin is from 15 to 35.

(Appendix 8) The color image forming method according to Appendix 6 or 7, wherein the infrared absorber is a compound which shows a light absorption peak at a wavelength ranging from 700 to 1000 nm.

[0070]

(Appendix 9) The color image forming method according to Appendix 8, wherein the infrared absorber is at least one compound selected from the group consisting of cyanine, anthraquinone, phthalocyanine, naphthalocyanine, polymethine, nickel complex, aminium, diimonium, tin oxide, ytterbium oxide, ytterbium phosphate, and cerium oxide.

[0071]

(Appendix 10) An apparatus for forming a color image on a recording medium by means of an electrophotographic system, comprising an image exposing device for forming an electrostatic latent image, a developing device for visualizing the electrostatic latent image, an image transferring device for transferring the visualized image onto the recording medium, and an image fixing device for fixing the transferred image onto the recording medium, wherein

the developing device is loaded with a developing agent containing a color toner, which comprises at least a binder resin, a colorant and an infrared absorber,

the binder resin containing, as a principal component, a polyester resin obtained by mixing a first polyester resin with a second polyester resin in a weight ratio of 80:20 to 20:80;

the first polyester resin being a non-linear polyester resin having a softening point Tsp of not lower than 120°C and lower than 170°C, and containing 1 to 25 parts by weight of a chloroform-insoluble content as a component thereof; and

the second polyester resin being a ~~non-linear~~ polyester resin having a softening point Tsp of not lower than 80°C and lower than 110°C; and

the image fixing device is provided with a photofixing device having a light emission energy density ranging from 1.0 to 6.0 J/cm<sup>2</sup>.

[0072]

(Appendix 11) The color image forming apparatus according to Appendix 10, wherein an acid value of the first polyester resin is from 20 to 40, an acid value of the second polyester resin is from 5 to 20, and an acid value of the entire polyester resin is from 15 to 35.

(Appendix 12) The color image forming apparatus according to Appendix 10 11, wherein the infrared absorber is a compound which shows a light absorption peak at a wavelength ranging from 700 to 1000 nm.

[0073]

(Appendix 13) The color image forming apparatus according to Appendix 12, wherein the infrared absorber is at least one compound selected from the group consisting of cyanine, anthraquinone, phthalocyanine, naphthalocyanine, polymethine, nickel complex, aminium, diimonium, tin oxide, ytterbium oxide, ytterbium phosphate, and cerium oxide.

[0074]

[Effect of the Invention]

According to the present invention, as described above, there can be provided an electrophotographic color toner which



allows it to use the photofixing system for fixing images, and is capable of improving both color toner fixability and void resistance in photofixation to the level of a monochromatic toner.

[0075]

Also according to the present invention, there can be provided a color image forming method and an color image forming apparatus, which allow it to effectively use the color toner of the present invention and fully achieve the effects thereof.

[Brief Description of the Drawings]

[Fig. 1]

Fig. 1 is a sectional view schematically showing a preferred example of an electrophotographic system for working the image forming method employing a flash fixing system for fixing the toner.

[Fig. 2]

Fig. 2 is a light emission spectrum of xenon flashlight.

[Description of Reference Numerals]

- 11: developing agent
- 12: stirring screw
- 13: developing roller
- 14: photosensitive drum
- 18: flash fixing device
- 21: recording medium
- 22: fixed image

[NAME OF DOCUMENT] Abstract

[ABSTRACT]

[OBJECT] To provide an electrophotographic color toner which allows it to use the photofixing system for fixing images, and is capable of improving both color toner fixability and void resistance in photofixation to the level of a monochromatic toner.

[MEANS FOR SOLVING THE PROBLEMS] In an electrophotographic color toner which is used in electrophotography employing a photofixing system, a binder resin, which contains, as a principal component, a polyester resin obtained by mixing a first polyester resin having a softening point Tsp of not lower than 120°C and lower than 170°C with a second polyester resin having a softening point Tsp of not lower than 80°C and lower than 110°C in a weight ratio of 80:20 to 20:80, is used.

[SELECTED DRAWING] None

提出日 平成13年 3月30日

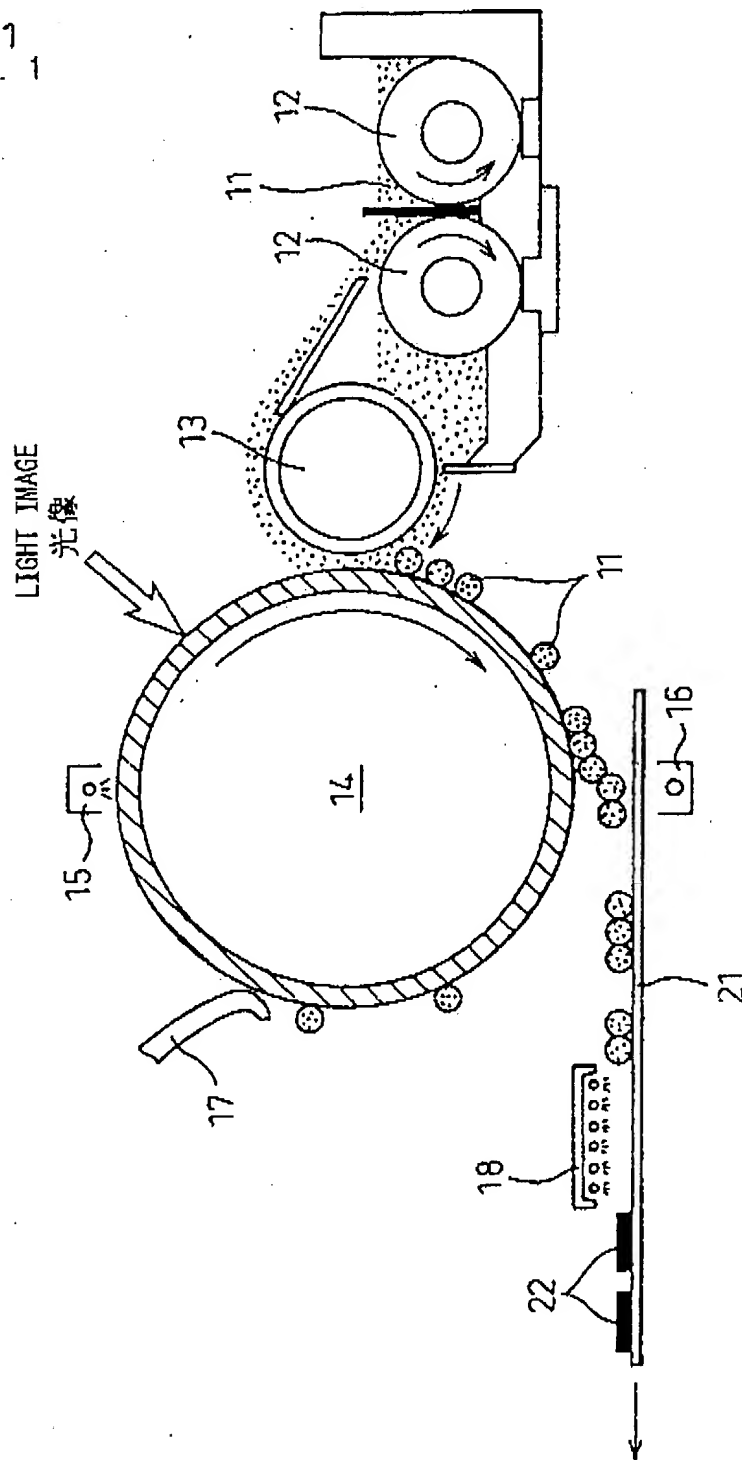
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整理番号=0150347

【書類名】 図面  
[NAME OF DOCUMENT] DRAWINGS  
【図1】  
[FIG. 1]



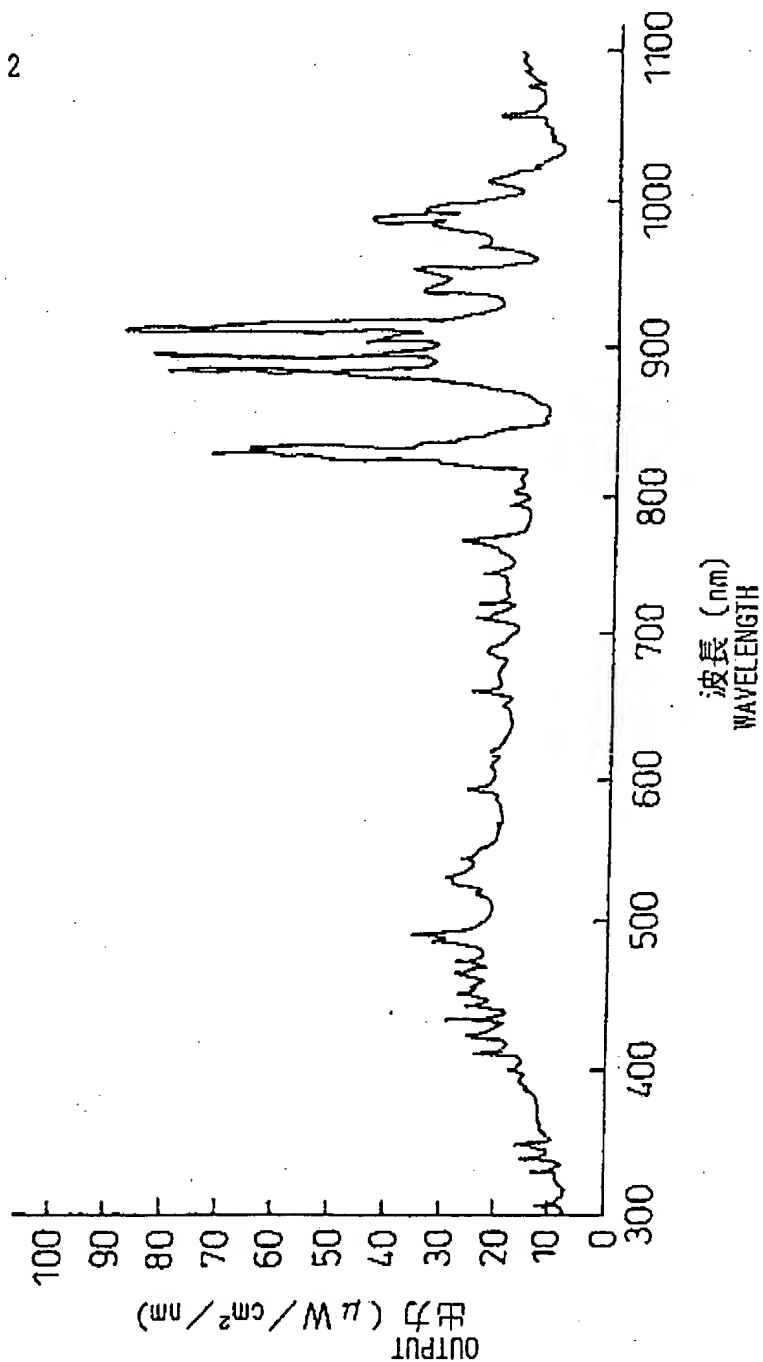
図1  
FIG. 1



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【図 2】  
[FIG. 2]図 2  
FIG. 2

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